

Work Order ID 60371

July 6, 2010 2:57:54 PM



Page 1

Item ID: D3783-045

Revision ID:

Accept

Item Name: Angle Brace Assembly

Start Date: 7/06/10 Start Qty: 4.00

Required Date: 7/20/10 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: CZ

Date: 10/7/6

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3783

Rev A

100



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

SB 10/07/15

(4)

110



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

1-assemble as per dwg D3783

SB 10/07/15

(6)

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Siolox15

(24)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60371

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Page 2

Item ID: D3783-045

Revision ID:

Item Name: Angle Brace Assembly

Start Date: 7/06/10

Start Qty: 4.00

Required Date: 7/20/10

Req'd Qty: 4.00

Reference:

Accept



Setup

Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Memo

0.00

0.00

Identify as per dwg & Stock Location 248

140



QC

Quality Control

Memo

0.00

0.00

QC21- Final Inspection - Work Order Release

10.7 - 19

MF

10-7-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 60371

Parent Item: D3783-045

Parent Item Name: Angle Brace Assembly

Start Date: 7/06/10

Start Qty: 4.00

Required Date: 7/20/10

Required Qty: 4.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-13A Bolt		Purchased	No			110	Each	70.0000	2	8			
					<u>Location</u>								
					ST338								
					114181			70					
					114615			20					
								50					
AN960JD516 Washer	NAS1149D0563J	Purchased	No			110	Each	0.0000	4	16			
D3765-1 Clevis		Manufactured	No			110	Each	11.0000	2	8			
					<u>Location</u>								
					ST250								
					56421			11					
								11					
D3769-5 Tube		Manufactured	No			110	Each	8.0000	1	4			
					<u>Location</u>								
					ST247			8					
					54345			8					

SB 10/07/15 (4)

SB 10/07/15 (4)

SB 10/07/15 (4)

SB 10/07/15 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 60371

Parent Item: D3783-045

Parent Item Name: Angle Brace Assembly

Page 2

12

MS21042L5



Nut

Purchased

No

110

Each

463.0000

2

8

Start Date: 7/06/10

Start Qty: 4.00

Required Date: 7/20/10

Required Qty: 4.00

Location

ST139

114813

Loc Qty

463

463

Loc Code

8

\$ 02/02/15 (4)

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Shop Packet Print

Page 2

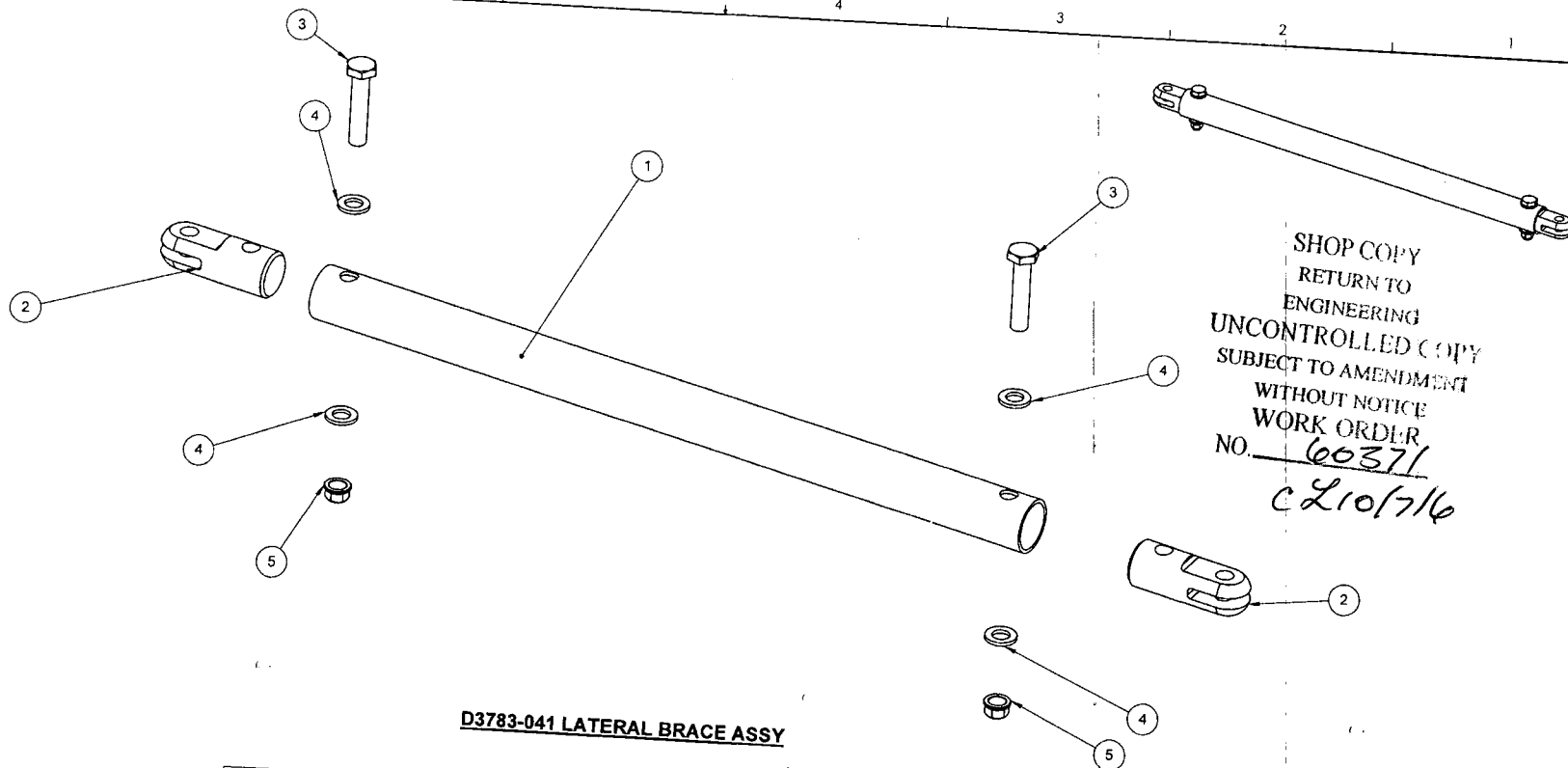
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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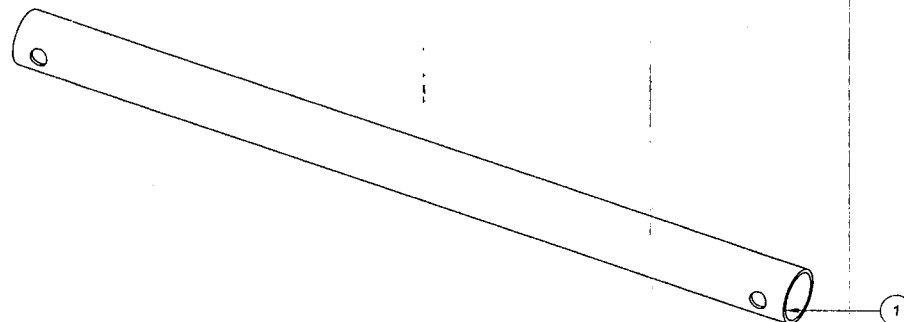
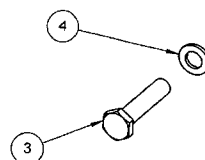
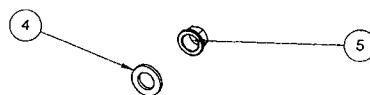
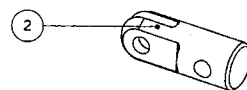
D3783-041 LATERAL BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3769-1	TUBE	1
2	D3765-1	CLEVIS	2
3	AN5-13A	BOLT	2
4	NAS1149D0568J	WASHER (AN960JD516)	4
5	MS21042L5	NUT	2

RELEASED
08.06.04

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.52 lbs

A		NEW ISSUE		HS		08.06.04	
REV.		DESCRIPTION		BY		DATE	
DESIGN	HS						
DRAWN	HS						
CHECKED							
MFG. APPR.							
APPROVED							
DE APPR.							
DATE	08.06.04						
				DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
				DRAWING NO. D3783			
				REV. A			
				SHEET 1 OF 3			
				TITLE BRACE ASSEMBLY			
				SCALE NTS			
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D3783-043 LONGITUDINAL BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3769-3	TUBE	1
2	D3765-1	CLEVIS	1
3	AN5-13A	BOLT	1
4	NAS1149D0568J	WASHER (AN960JD516)	1
5	MS21042L5	NUT	2

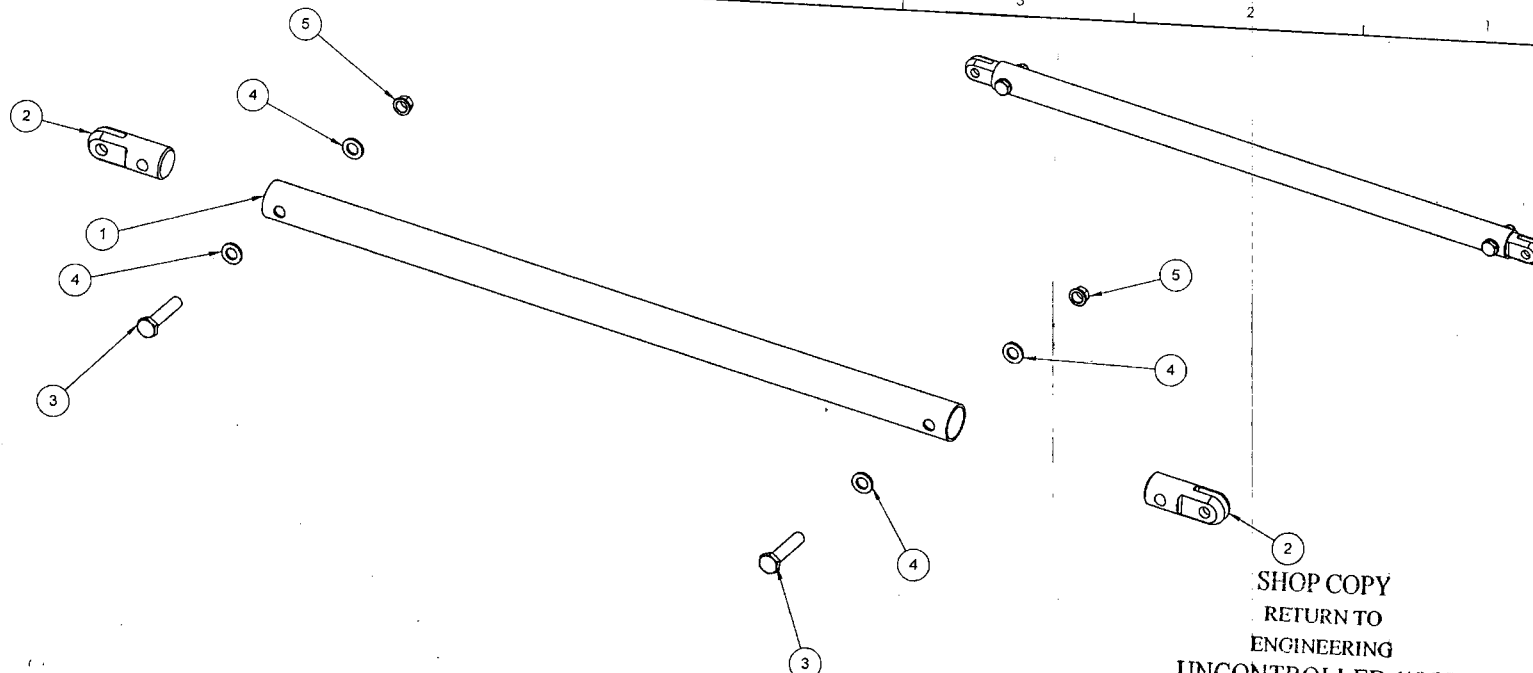
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08-06-15

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1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.41 lbs

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D3783-045 ANGLE BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3769-5	TUBE	1
2	D3765-1	CLEVIS	2
3	AN5-13A	BOLT	2
4	NAS1149D0568J	WASHER (AN960JD516)	4
5	MS21042L5	NUT	2

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.63 lbs

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DE APPR.		DATE 08.06.04	